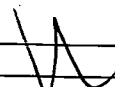
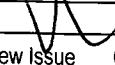


Date: Tuesday, 04/11/2008 8:33:59 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PANEL-W/O ROTOR BRAKE
Job Number :	43177		
Estimate Number :	13583		
P.O. Number :		Part Number :	D38211
This Issue :	04/11/2008	Drawing Number :	D38211 UNDER REVIEW
Prsht Rev. :	NC	Project Number :	IN0002
First Issue :	/ /	Drawing Revision :	A UNDER REVIW
Previous Run :	42065	Material :	MKYDEX 6185S80P362015
Written By :		Due Date :	14/11/2008
Checked & Approved By :		Qty:	2 Um: EACH
Comment :	Est. A New Issue 08/09/17 DL		

Additional Product

POSITIVE
RECALL

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MKYDEX6185S80P362015	Kydex velour matte, ivory
-----	----------------------	---------------------------



Comment: Qty.: 13.2489 sf(s)/Unit Total : 26.4978 sf(s)
Kydex velour matte, ivory

M 109703

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

08/11/04 WH

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

08/11/04 WH

4.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3821-1 and folio (FTA 9053 Prototype) using tool DT 9053

Dwg. Rev. A UNDER REVIEW
Folio Rev. A

08/11/04 WH

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE


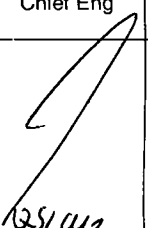
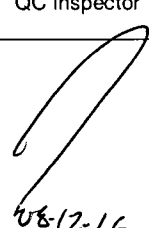
Visually inspect for proper formation of each part

08/11/04 WH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-16	5-D	1 part scrap. Part was formed as per mold & mold had aluminum trim rails that do not match the drawing. R-C: Tooling 1st time in use.	 05/04/2	Scrap: destroy remove aluminum rails on mold.			 05/04/2	 08-12-16

NOTE: Date & initial all entries

Date: Tuesday, 04/11/2008 8:33:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-W/O ROTOR BRAKE

Job Number: 43177

Part Number: D38211

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB 08/12/15 (X1)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/12/15 (X1)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

PH 08.12.22

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

NOT FOR STOCK, TESTING
PH 08.12.22

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion :



POSITIVE RECALL

EFFECTIVE 08.12.24 AUTH 4

RELEASED _____ DATE _____

CANCEL
PH 08.12.22

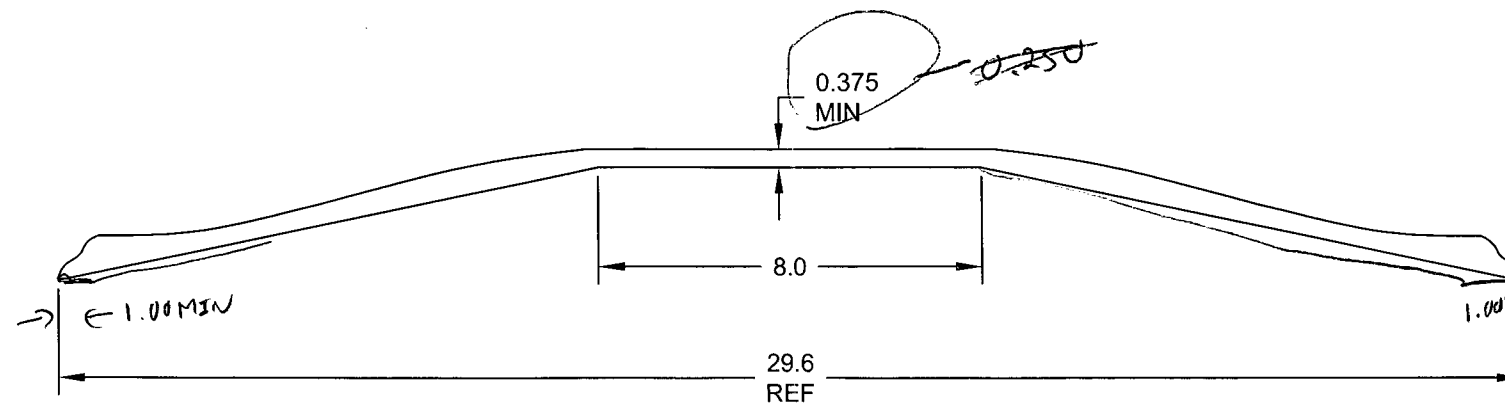
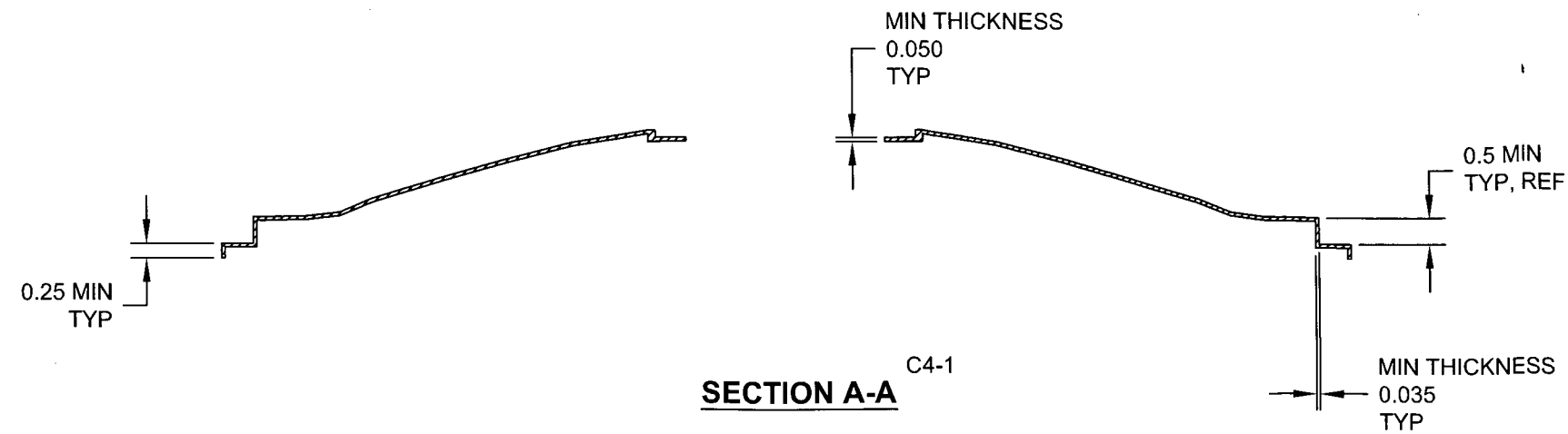
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3821	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	08.09.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order: 43177
Description: PANEL w/o Rotor Brake		Part Number: D3821-1
Inspection Dwg: D3821	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/12/15

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.040	Min	0.061	✓			2.008" mat'l
29.5 (Ref)	+/- 0.100	30.25		✓		Revise dim.
27.5 (Ref)	+/- 0.100	28.125		✓		Revise dim.
31.8 (Ref)	+/- 0.100	31.5		✓		Revise dim/should not be a Ref
3.0 (Ref)	+/- 0.100	3.0	✓			
100" TYP.	+0.0/-0.25	0.80	✓			
2.2 (Ref)	+/- 0.100	2.2	✓			Should not be Ref
4.6 (Ref)	+/- 0.100	4.75		✓		Revised dim/should not be Ref
6.1 (Ref)	+/- 0.100	6.1	✓			
0.7 TYP.	Min	0.625		✓		Revise dim (will achieve 2.2" 4.6"
19.0 (Ref)	+/- 0.100	19.0	✓			Should not be Ref.
20.5 (Ref)	+/- 0.100	20.500	✓			

Measured by: [Signature]

Date: 08-12-15

Audited by: [Signature]

Date: 08.12.15 / [Signature]

Prototype Approval: [Signature]

Date: [Signature]

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD		Work Order: 43177
Description: Panel w/o Rotor Brake/prototype		Part Number: D3821-1
Inspection Dwg: D3821 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by:	Date:
---------------------	--------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.4 (Ref)	± 0.100	1.4	✓			
1.9 (Ref)	± 0.100	2.0	✓			Revised dim
2.5 (Ref)	± 0.100	2.55	✓			
31.2 (Ref)	± 0.100	30.875		✓		Revised dim/should not be ref.
0.25 typ	Min	0.3	✓			
0.050	Min	0.055	✓			
0.5	Min	0.53	✓			
0.035	Min	0.052	✓			
0.375	Min	0.380	✓			
8.0	± 0.100	8.0	✓			

Measured by:	Date: 08-12-16
Audited by:	Date: 08.12.16
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	